

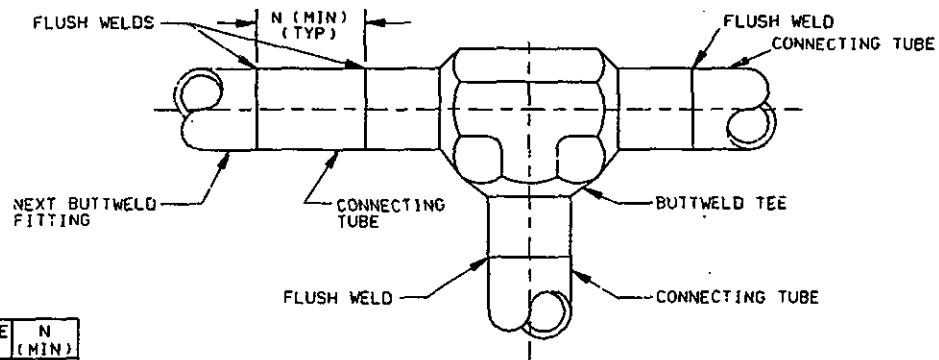
NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY NOR ANY OBLIGATION WHATSOEVER AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS, OR OTHER DATA IS NOT REGARDED BY IMPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERE TO.

NASA		FED SUP CLASS 4730
<p>SCHEDULE:</p> <p>ADD "A" AFTER DASH NUMBER TO DENOTE .035" TUBE WALL. ADD "B" AFTER DASH NUMBER TO DENOTE .049" TUBE WALL. ADD "C" AFTER DASH NUMBER TO DENOTE .058" TUBE WALL. ADD "D" AFTER DASH NUMBER TO DENOTE .065" TUBE WALL. ADD "E" AFTER DASH NUMBER TO DENOTE .072" TUBE WALL. ADD "F" AFTER DASH NUMBER TO DENOTE .095" TUBE WALL. ADD "G" AFTER DASH NUMBER TO DENOTE .109" TUBE WALL. ADD "H" AFTER DASH NUMBER TO DENOTE .120" TUBE WALL. ADD "J" AFTER DASH NUMBER TO DENOTE .134" TUBE WALL. ADD "K" AFTER DASH NUMBER TO DENOTE .156" TUBE WALL. ADD "L" AFTER DASH NUMBER TO DENOTE .188" TUBE WALL.</p>		
<p>MATERIAL: SEE PROCUREMENT SPECIFICATION. CORROSION RESISTANT STEEL (CLASS 316), CODE "K"</p>		
<p>FINISH: SURFACE SHALL BE 125 RMS MAXIMUM PER ANSI B46.1 UNLESS OTHERWISE SPECIFIED.</p>		
<p>NOTES:</p> <ol style="list-style-type: none"> REMOVE BURRS AND SLIVERS. BREAK SHARP EDGES UNLESS OTHERWISE NOTED. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE DECIMALS $\pm .016$. FOR DESIGN FEATURE PURPOSES, THIS DRAWING TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON THE DATE OF INVITATION FOR BID. MARKING OF FITTINGS SHALL BE CONSISTANT WITH PROCUREMENT SPECIFICATION USING APPLICABLE KC STANDARD AND PART NUMBER DESIGNATIONS AS SHOWN ON THIS DRAWING. ALL DIAMETRAL DIMENSIONS SHALL BE CONCENTRIC WITH "C" BORE WITHIN .005 T.I.R. FITTINGS PROVIDED HEREIN SHALL BE WELDED TO CORRESPONDING TUBE SIZES USING AUTOMATIC WELDING EQUIPMENT (ASTRO-ARC CO. OR EQUIVALENT). 		
<p>EXAMPLE OF PART NOS.</p> <p>KC148K4A = TEE, BUTTWELD TUBE, FOR 1/4" X .035 WALL TUBING.</p>		
<p>CUSTODIAN: JOHN F. KENNEDY SPACE CENTER</p>		
<p>PROCUREMENT SPEC. KSC-F-124</p>		<p>STANDARD PART KC148</p>
<p>COORDINATION STATUS KSC DE</p>		<p>SHEET 1 OF 2</p>

KSC FORM 32-85 (CG 4/92)

FED SUP CLASS
4730

DASH NO.	TUBE SIZE REF	A ±.003	B +.005 -.000	C ±.003	D +.005 -.000	E ±.003	F ±.005	G ±.005	H +.015 -.005	J (REF)	K ±.016	L (REF)	M (REF)	R ±.005
K4A	1/4" X .035	.285	.255	.172	.258	.297	.350	.385	.656	.680	.920	15	.438	.030
K6A	3/8" X .035	.410	.380	.297	.383	.428	.350	.385	.718	.742	1.110	15	.563	.030
K6C	3/8" X .050	.410	.380	.251	.383	.428	.350	.385	.718	.742	1.110	15	.563	.030
K8B	1/2" X .049	.546	.506	.393	.509	.554	.350	.385	.780	.812	1.280	15	.750	.030
K8E	1/2" X .072	.546	.506	.347	.509	.554	.350	.385	.780	.812	1.280	15	.750	.030
K12D	3/4" X .065	.816	.756	.611	.759	.804	.500	.535	.868	.909	1.640	15	1.063	.030
K12G	3/4" X .109	.816	.756	.523	.759	.804	.500	.535	.868	.909	1.640	15	1.063	.030
K16F	1" X .095	1.066	1.006	.801	1.009	1.054	.500	.535	.868	.909	1.810	15	1.313	.030
K16H	1" X .120	1.066	1.006	.751	1.009	1.054	.500	.535	.868	.909	1.810	15	1.313	.030
K20B	1 1/4" X .049	1.330	1.256	1.143	1.259	1.304	.500	.535	.930	1.036	2.090	30	1.625	.060
K20J	1 1/4" X .134	1.330	1.256	.973	1.259	1.304	.500	.535	.930	1.036	2.090	30	1.625	.060
K24B	1 1/2" X .049	1.605	1.511	1.398	1.514	1.559	.500	.535	.930	1.034	2.280	30	1.875	.060
K24J	1 1/2" X .134	1.605	1.511	1.218	1.514	1.559	.500	.535	.930	1.034	2.280	30	1.875	.060
K24K	1 1/2" X .156	1.605	1.511	1.174	1.514	1.559	.500	.535	.930	1.034	2.280	30	1.875	.060
K24L	1 1/2" X .188	1.605	1.511	1.120	1.514	1.559	.500	.535	.930	1.034	2.280	30	1.875	.060
K32D	2" X .065	2.105	2.011	1.866	2.014	2.059	.500	.535	1.055	1.298	3.060	45	2.500	.375
K32L	2" X .188	2.105	2.011	1.620	2.014	2.059	.500	.535	1.055	1.298	3.060	45	2.500	.375



TUBE SIZE REF	N (MIN)
1/4"	1.44
3/8"	1.44
1/2"	1.44
3/4"	1.44
1"	1.44
1 1/4"	1.63
1 1/2"	1.63
2" X .065	1.75
2" X .188	4.25

BUTTWELD TEE APPLICATION DATA

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CUSTODIAN:

JOHN F. KENNEDY SPACE CENTER

PROCUREMENT SPEC.
KSC-F-124

COORDINATION STATUS

KSC DE

TEE, BUTTWELD TUBE

STANDARD PART

KC148

SHEET 2 OF 2

KSC FORM 32-85 (CG 4/92)

REVISED: ○

APPROVED: 5-1-90